

Date: Monday, 26/01/2009 11:39:22 AM
 User: Melanie Fautéux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD LEG ASS'Y
Job Number :	45235		
Estimate Number :	13175		
P.O. Number :		Part Number :	D3684047
This Issue :	26/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3684 REV C
First Issue :	/ /	Project Number :	N/A
Previous Run :	44681	Drawing Revision :	C
	Type :	Material :	
	MACHINED PARTS	Due Date :	28/01/2009
Written By :		Qty:	2
		Um:	Each
Checked & Approved By :	<u>MF 09-01-26</u>		
Comment :	Est Rev:A new issue 08-02-12 DD verified by:JLM Est Rev:B As per Rev B 09-01-07 JLM Vérified By:EC Est Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

2.0	D36881	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

STUD

batch

44823

MF 09-01-28

3.0	D36891	SLEEVE
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

SLEEVE

batch

44687

MF 09-01-28

4.0	D36911	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

STUD

batch

44688

MF 09-01-28

5.0	D36921	SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPACER

batch

44527

MF 09-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/01/2009 11:39:22 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD LEG ASS'Y

Job Number: 45235

Part Number: D3684047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36931

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rod End Bearing

batch B44691

MF 09-01-27

7.0

AN3C12A

Bolts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolts

batch m106993

MF 09-01-27

8.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch m110023

MF 09-01-27

9.0

NAS509L12C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nuts

batch m106993

MF 09-01-27

10.0

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nuts

batch 106993

MF 09-01-27

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

MF 09-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/01/2009 11:39:22 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD LEG ASS'Y

Job Number: 45235

Part Number: D3684047

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

80860128 (x2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

45215, 45216

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/29

Job Completion



MF 09-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

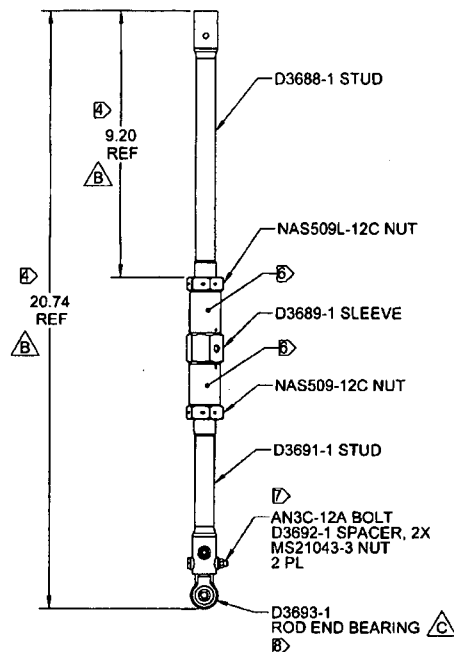
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT






D3684-047 FWD LEG ASSEMBLY

45235

RELEASED
09/01/12

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.10 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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